

Date: Wednesday, 22/04/2009 1:52:59 PM
 User: Melanie Fauteux

Process Sheet

See PD

Page 12

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47380-1
 Estimate Number : 13852
 P.O. Number :
 This Issue : 22/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 47233
 Part Number : D35704 GY
 Drawing Number : D3570 REV D PRELIM
 Project Number : N/A
 Drawing Revision : D PRELIM
 Material :
 Due Date : 23/04/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : MF 09-04-22
 Comment : Est Rev:A New Issue 09.04.14 EC verified by:DD

Additional Product

Job Number:

PRELIMINARY ISSUE

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.2982 sf(s) 6061-T6 .125 Sheet Batch: 110067 1B9-4-22 1B9-4-24 ***Grain must be Along 4.63"*****		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3570 Dwg Rev: PRE 1B9-4-22 Prog Rev: 2im 1B9-4-24 2-Deburr if necessary 1B9-4-22 1B9-4-24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK ENGINEERING APPROVAL 09.04.25 09.04.25		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Form as per Dwg D3570 Using DT8945		

B: BRACKET

r: D35704

Description :

NT STEP

EERING
ROVAL

E #1

09-06-201

CHEMICAL CONVERSION

arker, then Stock

LEASE

 POSITIVE RECALL
 EFFECTIVE 09/04/22
 RELEASED 09/04/22
AUTH
DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3570-4 PAR #: N/A Fault Category: Im fab NCR: Yes No DQA: Yes Date: 090707
Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 090713

NCR: <u>47380</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/08	S.O	Found @ inspection that all 4 parts were bent too short. B Dwg Ask for 390 Measur About 3.810"	09.04.23 P02.051 042	Scrap and Destroy Qty (4) 110660 Repln B2 110662	FF 09-04-24 #3 9-4-08	S 09/07/01	09.04.23 P02.051 042	S 09/07/01
		R.C. Improper technique, L.O.A.		AND Re Bend.				

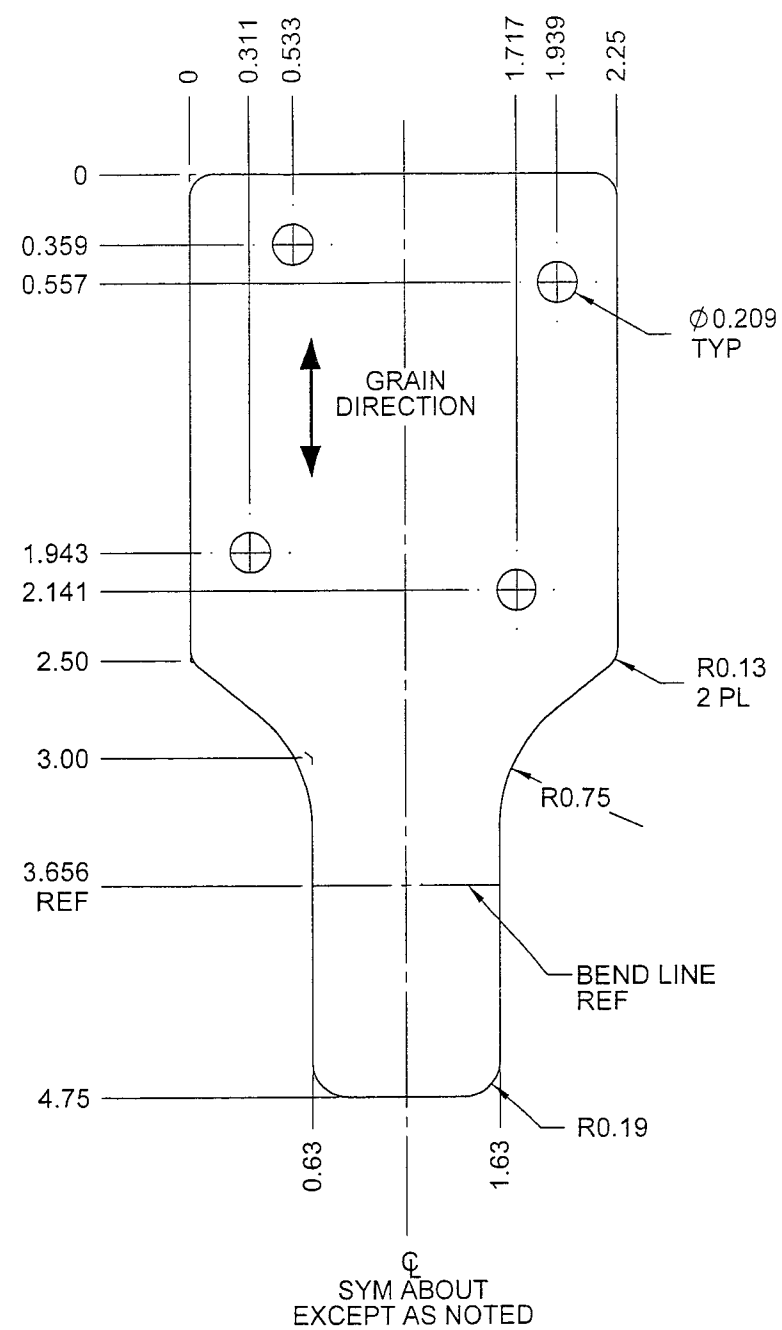
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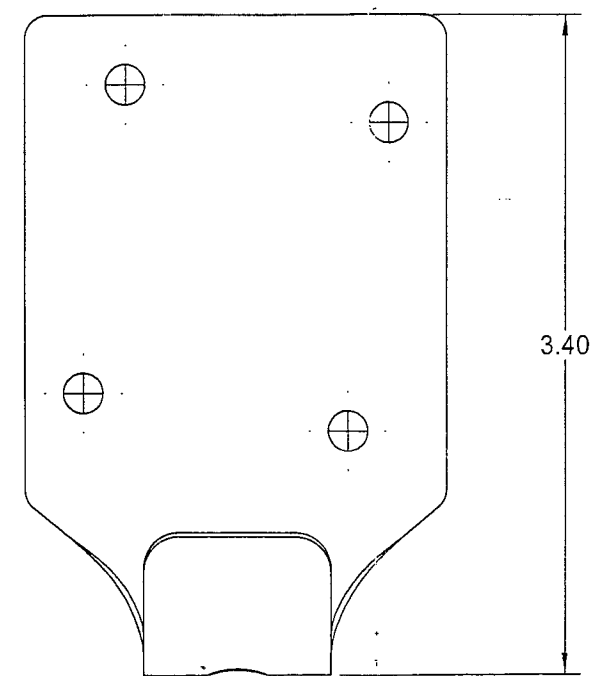
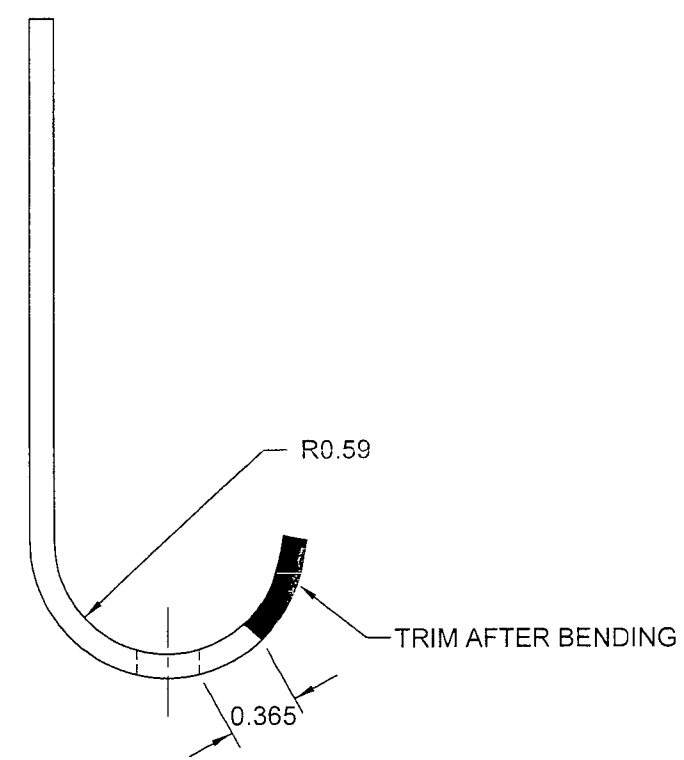
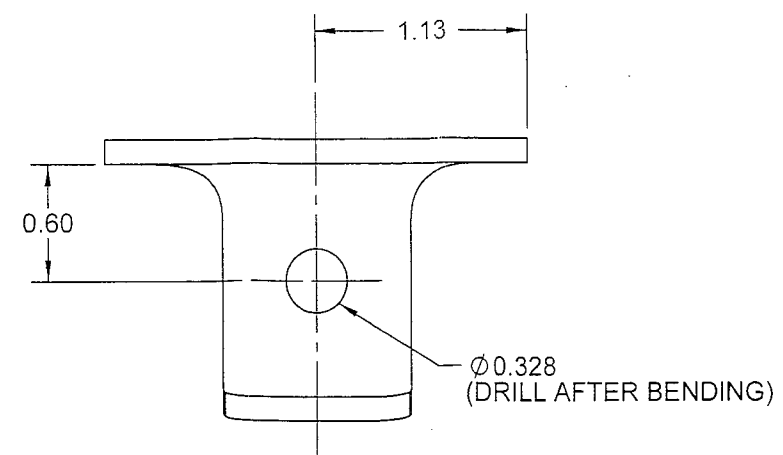
5412-702

NOTE: Date & initial all entries

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D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FOM D3570-1F)

47380

PRELIMINARY
ISSUE
AJS 01.04.22

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MFG. APPR.		D3570	SHEET 2 OF 5
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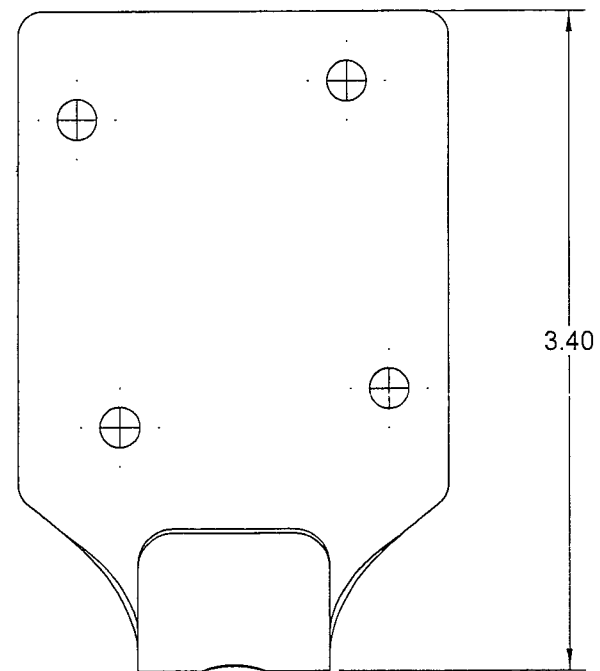
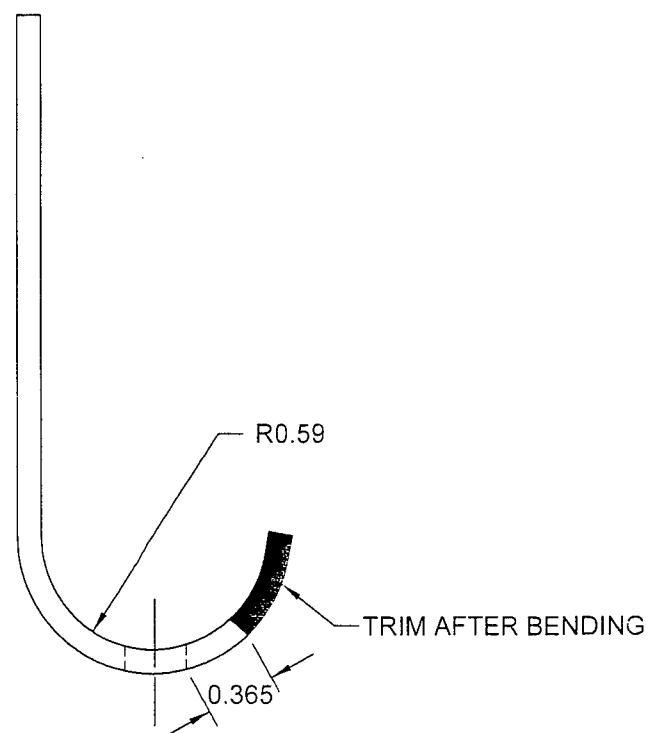
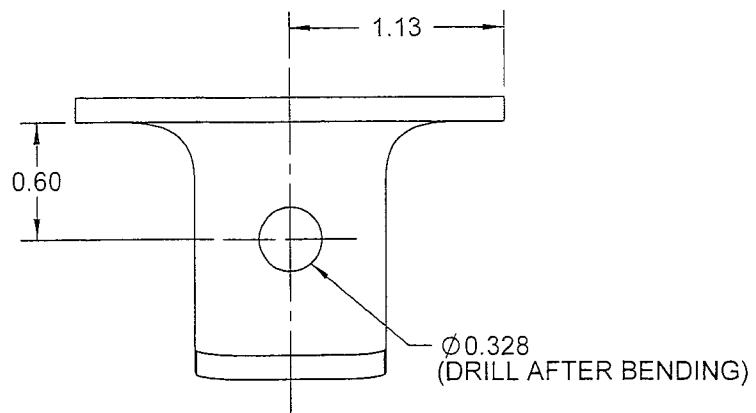
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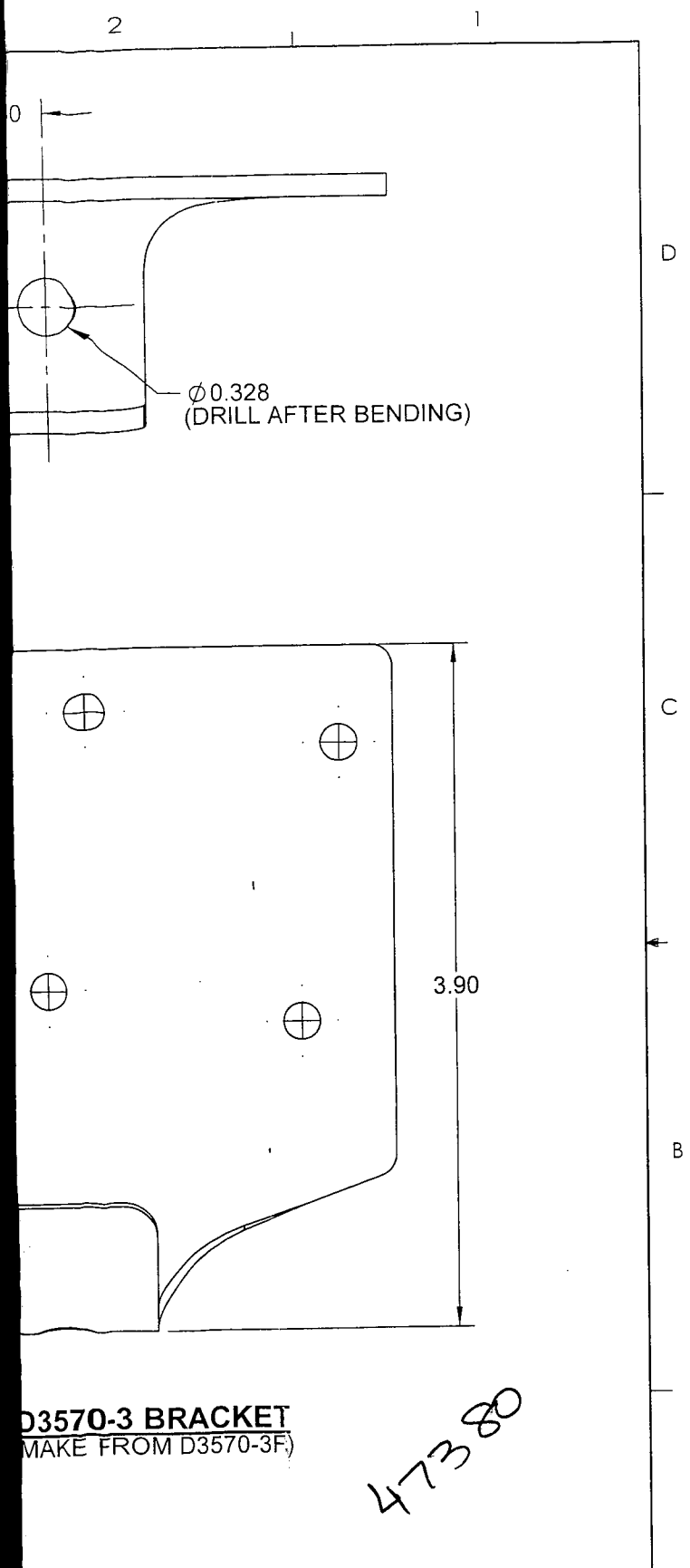


D3570-2 BRACKET
(MAKE FROM D3570-1F)

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AJS 09.04.22

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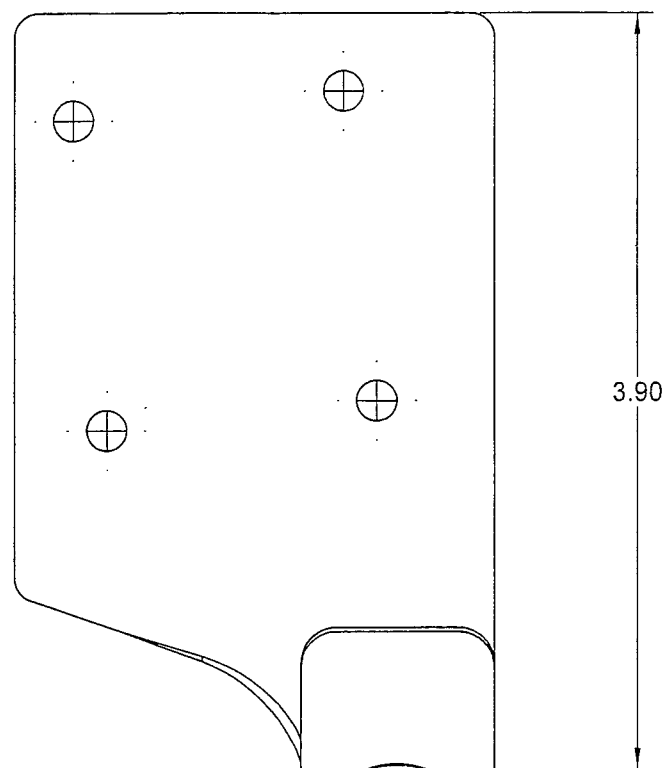
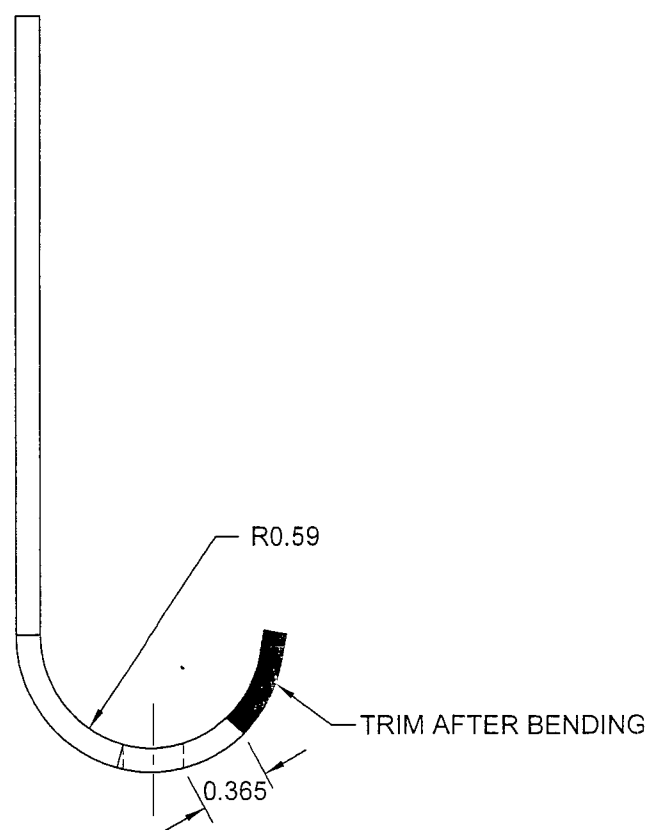
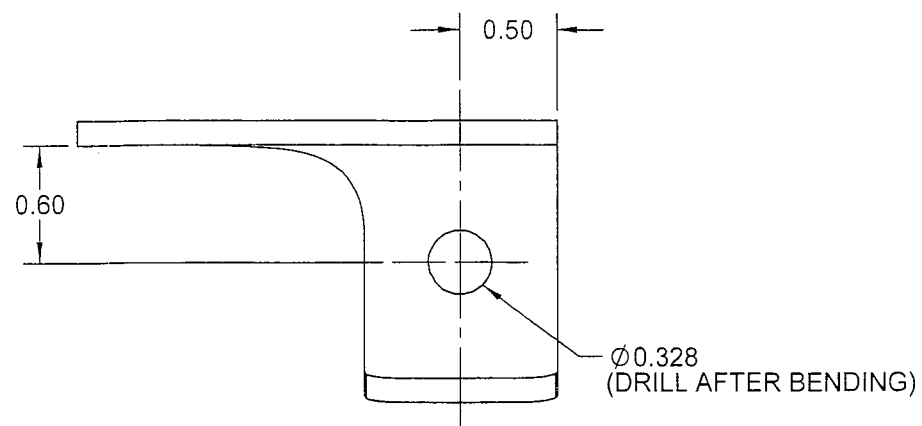
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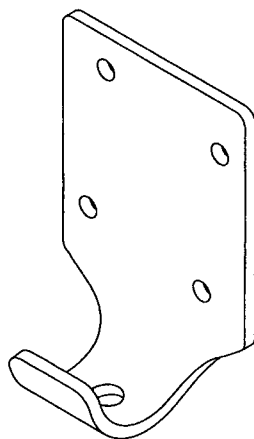


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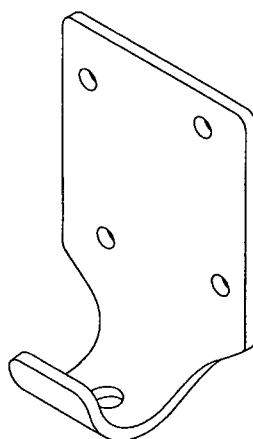
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AJS 09.04.22

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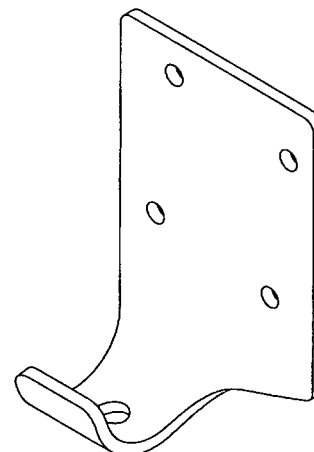
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DATE	09.04.22		



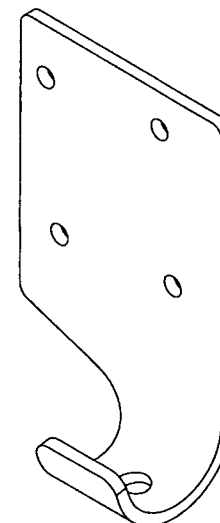
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

RELEASED
09/04/22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

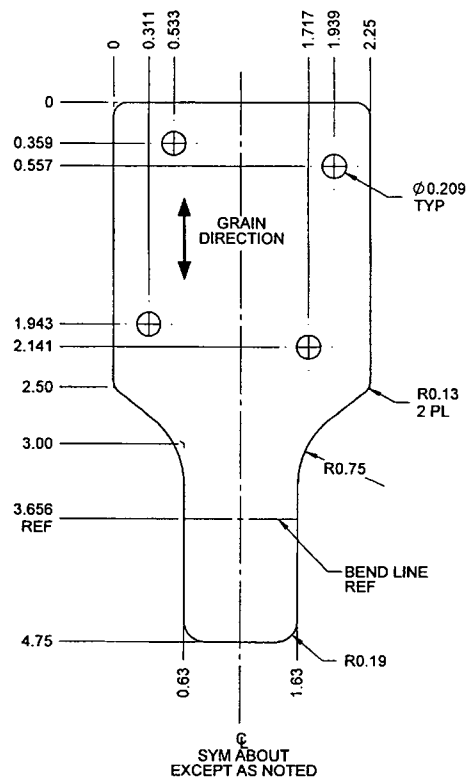
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REV.	DESCRIPTION	BY	DATE
E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07

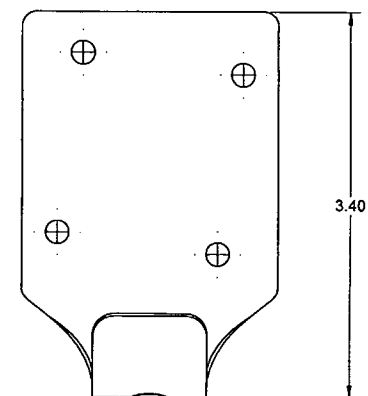
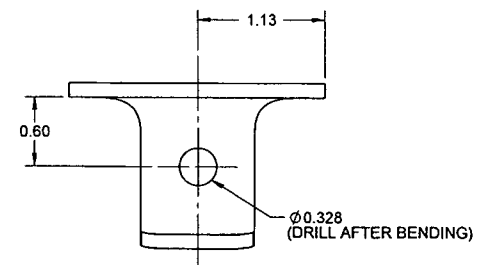
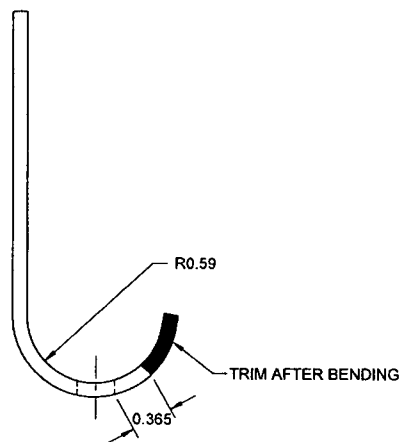
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REV. E
SHEET 1 OF 5

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D3570-1F FLAT PATTERN

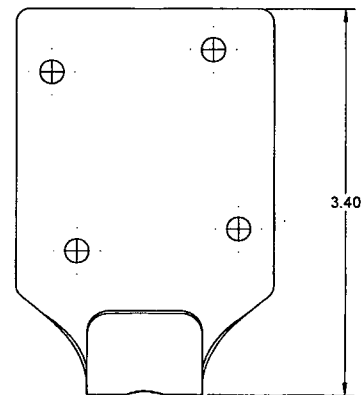
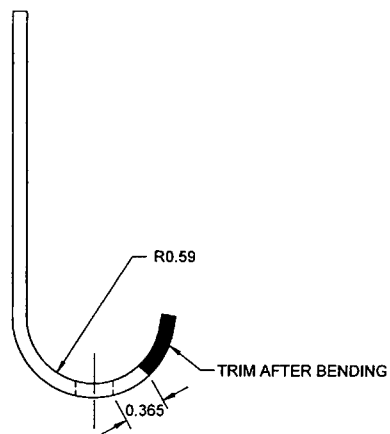
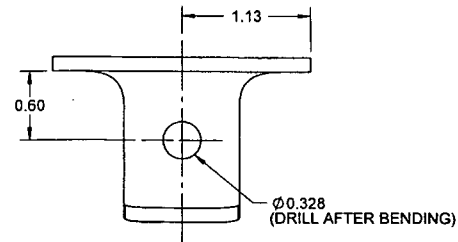


D3570-1 BRACKET
(MAKE FOM D3570-1F)

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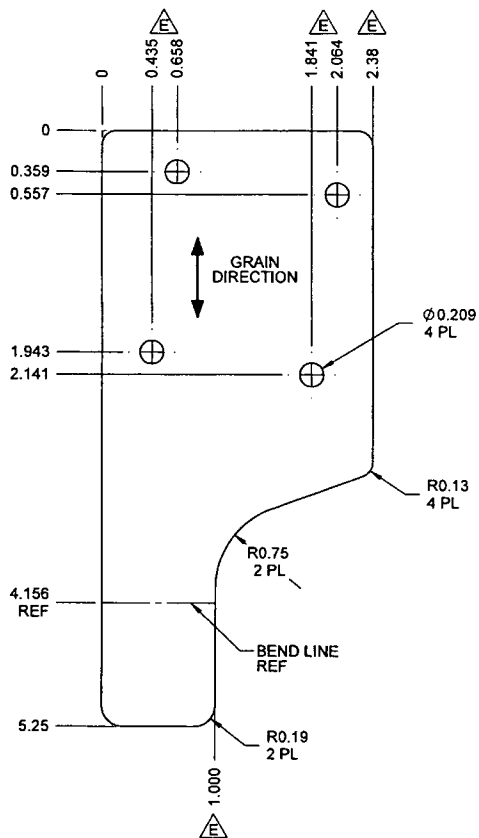


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(MAKE FROM D3570-1F)

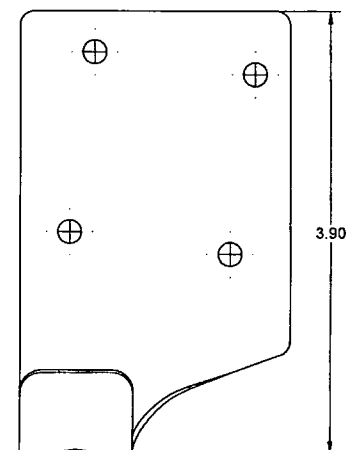
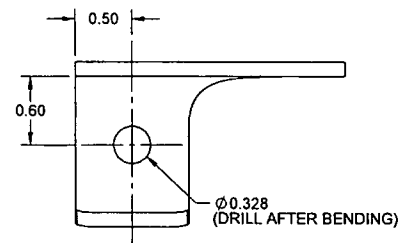
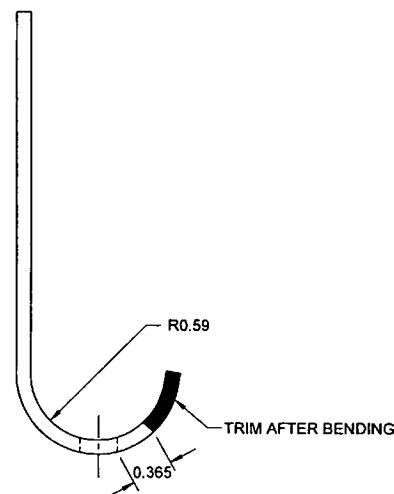
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D3570-3F FLAT PATTERN

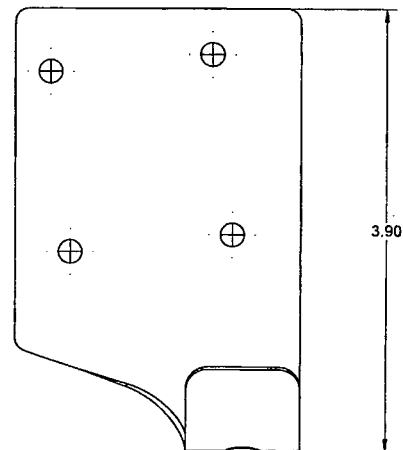
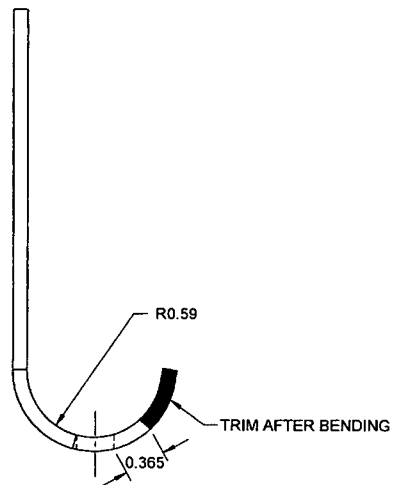
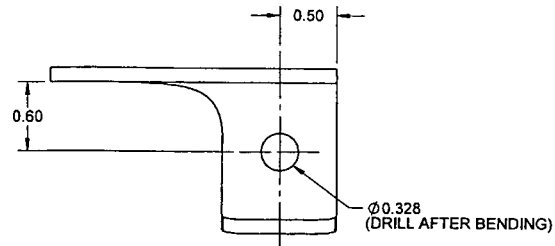


D3570-3 BRACKET
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D3570-4 BRACKET
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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